

Work Order ID 149775

149775

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August 03, 2016 3:15:28 PM

Item ID: D205-579-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Dual Battery Rack

Stop ***NS2***

Start Date: 8/2/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 1.00

1

Customer: CTHRE03

Reference: RMA RA112335

Approvals: Process Plan: SM Date: 8/3/16

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D204/5-579	Rev B

100

0.00

100

QC

Quality Control

Memo

0.00

INSPECT D205-579-015 B119308 X1 ON RA 112335

PD 16-03-06

ID WITH NEW B/N AND RETURN TO STOCK WITH NEW PAPERWORK
AND LABELS

ad chg 002

110

Identify as per dwg & Stock Location: fg 017 0.00

110

Packaging

Packaging

Memo

0.00

DAS

27

9-59

AUG 4 0 2016

120

QC21- Final Inspection - Work Order Release 0.00

120

QC

Quality Control

Memo

0.00

DART AEROSPACE		1270 ABERDEEN ST HAWKESBURY, ON CANADA K6A 1K7 TEL 1-613-632-5200 www.dartaerospace.com	
PATENT	N/A	CHG	CHG002
P/N	D205-579-015	STC	SH92-19
DESC.	Dual Battery Rack	STC	SH1004NE
LOT	B119308	STC	
MODEL	Bell 204/205	STC	
TC APPROVAL # 09-89		MADE IN CANADA	

16.08.10
16/08/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 149775

149775

Parent Item: D205-579-015

D205-579-015

Parent Item Name: Dual Battery Rack

Start Date: 8/2/2016

Required Date: 8/3/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B As per Rev B 06-03-07 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-579-015		Manufactured	No				Each	0.0000		1			
D205-579-015									**				
Dual Battery Rack													

B119303 16-03-06 PD

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-579-015 Dual Battery Rack Kit	22.3 lb 10.15 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	10.5 in 0.27 m	234.2 in lb 2.74 m kg

5.0 PARTS LIST

-015	Part Number	Description
X	D205-579-015	DUAL BATTERY RACK KIT
4 ✓	D2121	CLAMP ASSEMBLY
4 ✓	D3247-1	ANGLE
1 ✓	D3249-1	TOP
1 ✓	D3250-1	BACK
1 ✓	D3251-041	CENTRE DIVIDER
1 ✓	D3252-1	LARGE SHELF
1 ✓	D3253-1	SMALL SHELF
1 ✓	D3254-041	SIDE (LH)
1 ✓	D3254-2	SIDE (RH)
1 ✓	D3261-1	BATTERY CASE TRAY
212 ✓	MS20470AD4-5	RIVET
17 ✓	MS20470AD4-7	RIVET